

# Work Order ID 70998

Tuesday, June 21, 2011 8:58:23 AM



Page 1

Item ID: D2804-041

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 6/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2804

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-1 Into arm as per Dwg D2804

*EP 11/08/09* (Signature)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Subslog*

(Signature)

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: *9:30 PM* OVEN TEMPERATURE:  
FINISH TIME: *10:00 PM* *320° F*

*4* *11/08/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							4x Ø M-L 11/08/11
140  Small Fab Small Fab Small Fab	Small Fab  Memo Press D2809 into arm as per Dwg D2804	0.00  0.00							EP 11/08/11 (4)
150  Small Fab Small Fab Small Fab	Small Fab  Memo 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 □2-Assemble as per Dwg D2804.	0.00  0.00							EP 11/08/11 (4)

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 3

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Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 6/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				<u>24</u>			
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>1-30</u>  Memo	0.00 0.00				<u>11/8/12</u>		<u>42</u>	
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							<u>11/8/16</u> <u>MF</u> <u>11-08-15</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 21, 2011 8:58:29 AM

Page 1

Work Order ID: 70998

Parent Item: D2804-041

Parent Item Name: Bracket Assembly





Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM  
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-1  Bracket		Manufactured	No			100	Each	0.0000	1	2		6/11/08/09	
D2805-1  Stop		Manufactured	No			100	Each	8.0000	1	2		6/11/08/09	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				8					
					62247			8					
NAS1515H3  Washer		Purchased	No			100	Each	96.0000	4	8		6/11/08/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST277				96					
					116373			6					
					117460			90					
AN3C16A  Bolt		Purchased	No			150	Each	29.0000	2	4		6/11/08/11	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST352				29					
					115835			29					

16x  
M118078  
M118191 (8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, June 21, 2011 8:58:29 AM

Page 2

Work Order ID: 70998

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 2.00

Required Qty: 2.00

~~X~~ D2809  
Bushing

Manufactured No

150 Each

22.0000

1

Location

Loc Qty

Loc Code

ST

10

70805

10

ST023

12

34035

12

MS21043-3

Purchased No

150 Each

1,215.000

2

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1143

112314

143

118077

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

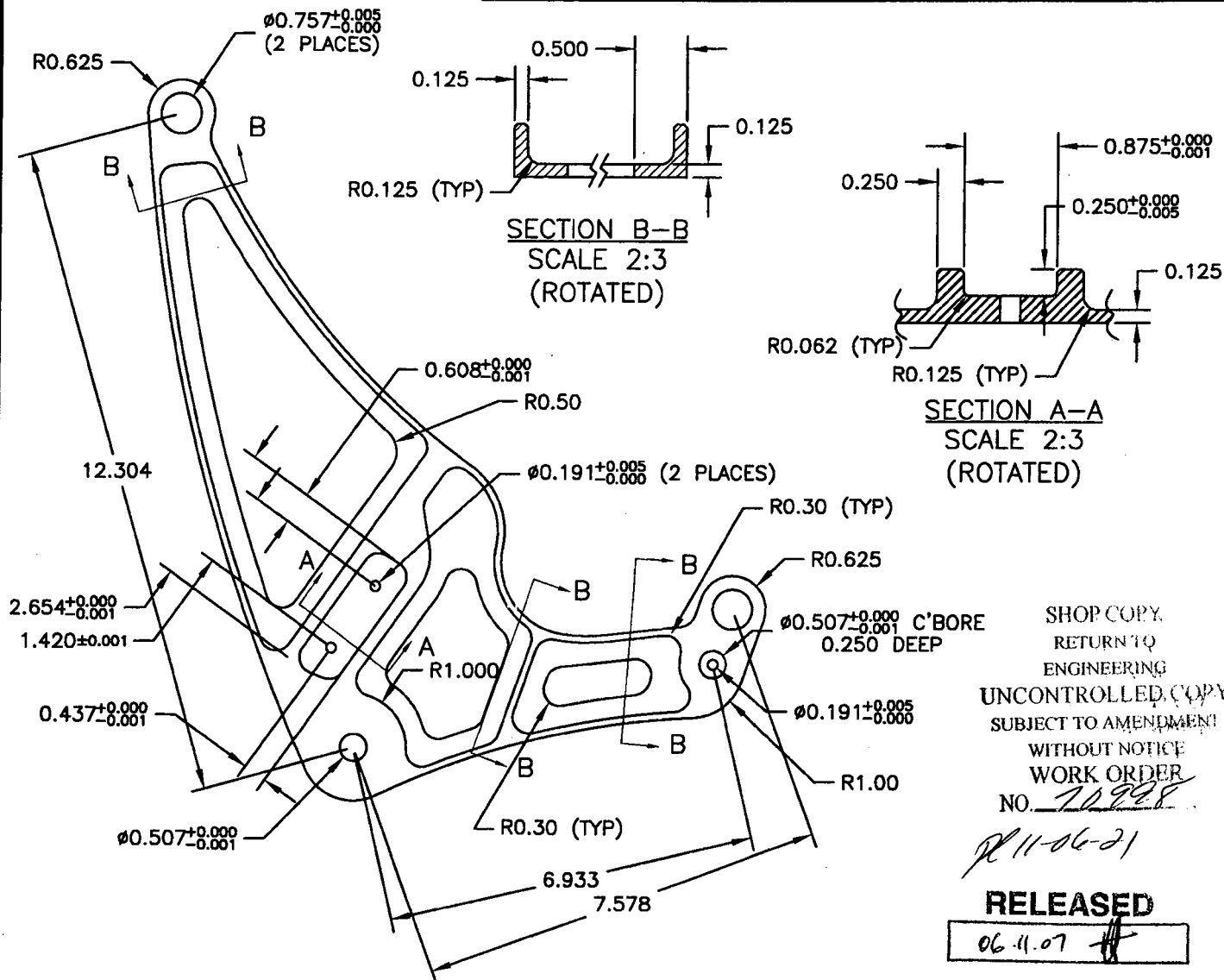
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



SHOP COPY.  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70928

RELEASED

06.11.07 H

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

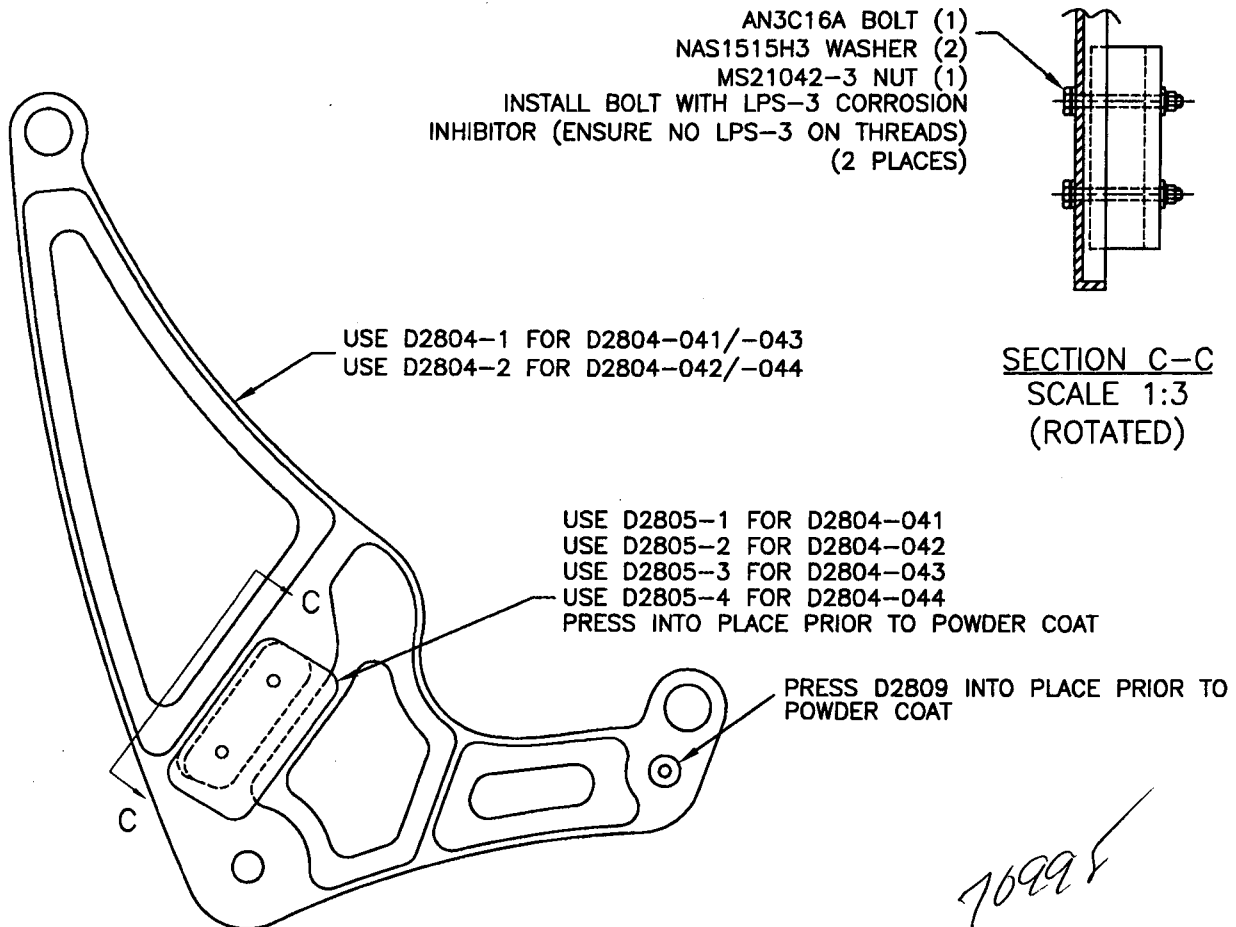
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C  
SCALE 1:3  
(ROTATED)

**RELEASED**

06.11.07

**D2804-041/-043 BRACKET ASS'Y (SHOWN).****D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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